

Work Order ID 165229

Thursday, August 17, 2017 7:30:58 AM

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Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Upper Rib Assembly
Start Date: 8/17/2017 Start Qty: 8.00 ***8*** **DAS 21 9-89** Cust Item ID:
Required Date: 8/21/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: AUG 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						DAS 24 9-89		
D4034	C								

100 Weld per dwg A/R S.S. rod Batch: 135068 0.00***100***

Large Fab

Memo 5.28

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

4x 2017-08-25

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo 0.00

Quality Control

④ 17-08-25 AD

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo 0.16

Quality Control

④ 17-08-15 AD

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: WA4	0.00				4	AUG 28 2017		DAS 24 9-89
130									
Packaging	Memo	0.08							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.80							
Quality Control									

17/9/5

DAS 21 9-89**AUG 28 2017**

Picklist Print

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Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 8/17/2017

Required Date: 8/21/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER
DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG
REV.pc1 DD VERF:JLM IPP Rev:E 13.06.21 DWG REV.C DD
VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1		Manufactured	No			100	Each	14.0000	1	8			
									**	DC 2017-08-24			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		14	B161999 →	4					
					161999	14							
D4034-3		Manufactured	No			100	Each	14.0000	1	8			
									**	DC 2017-08-24			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		14	B164636 →	4					
					164073	2							
					164636	12							
D4021-7		Manufactured	No			100	Each	8.0000	1	8			
									**	DC 2017-08-24			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		8	B164271 →	4					
					163719	2							
					164271	6							

Picklist Print

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Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 8/17/2017

Required Date: 8/21/2017

Start Qty: 8.00

Required Qty: 8.00

✓ D4021-9

Manufactured No

100

Each

68.0000

4

32

D4021-9

**

Bushing

DC 2017-08-24

Location

Loc Qty

Loc Code

WA004

68

57

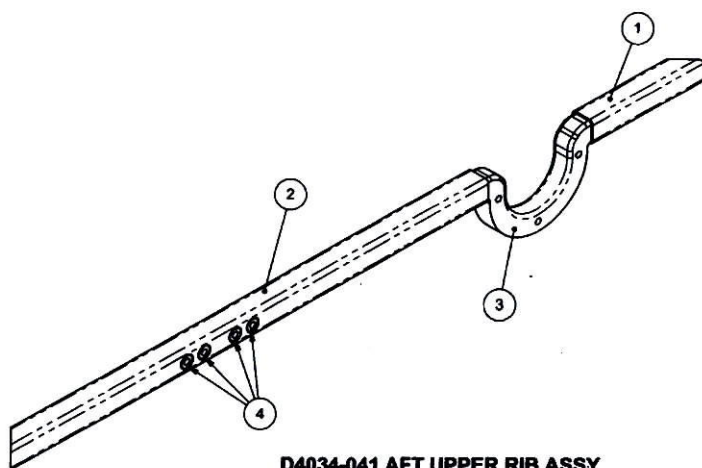
11

163982

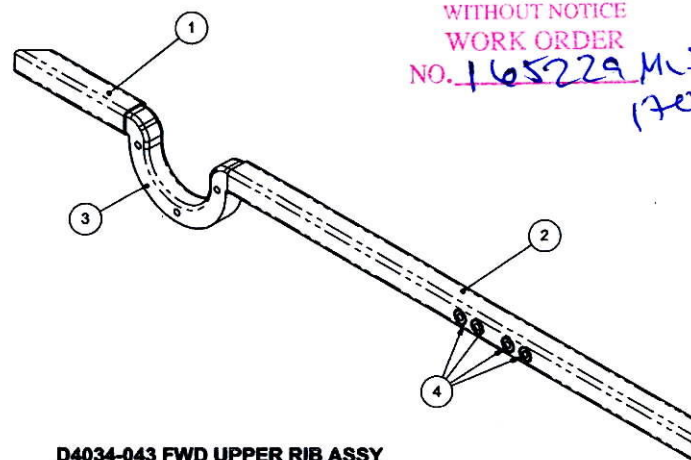
164511

B/63982 → 16

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY

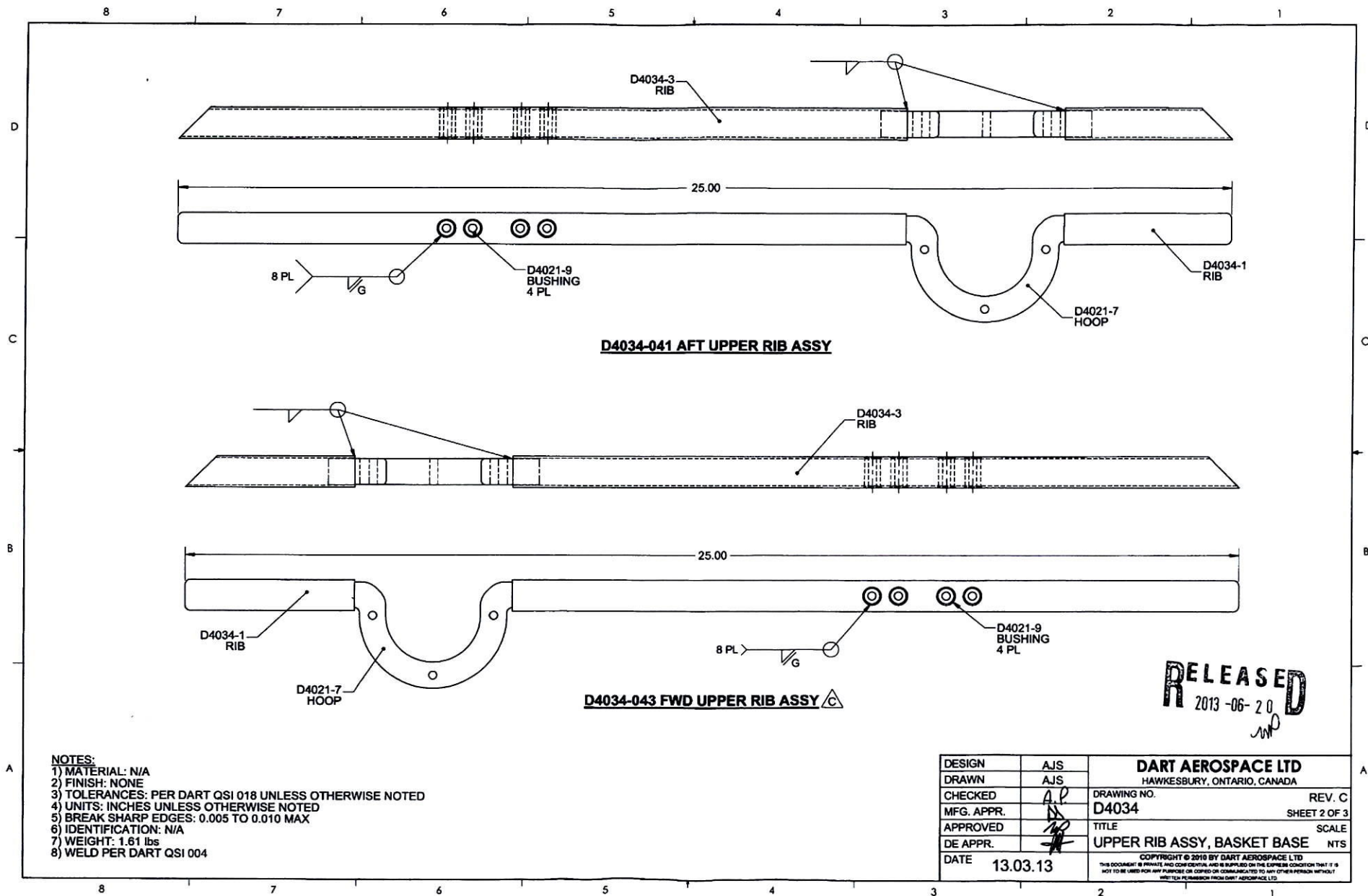


D4034-043 FWD UPPER RIB ASSY

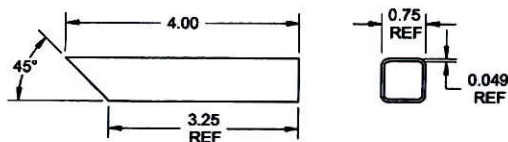
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165229 MJS
1708-17

RELEASED
2013-06-20
AM

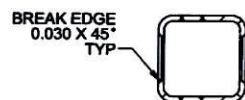
C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.	AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4034 REV. C SHEET 1 OF 3 TITLE UPPER RIB ASSY, BASKET BASE SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	A.P.		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS		
DATE	13.03.13		



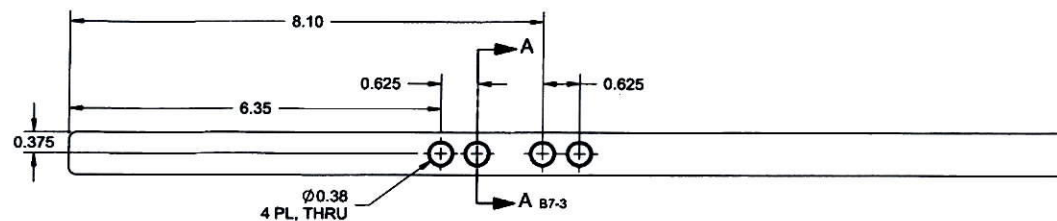
RELEASED
2013-06-20



D4034-1 RIB



SECTION A-A C3-3



D4034-3 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

RELEASED
2013-06-28

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	AS	D4034	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	UPPER RIB ASSY, BASKET BASE	NTS
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